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RBE703A94-1130-01
Job Sheet 183084



Part No: RBE703A94-1130-01 *PD* Job Qty: 3 ea

Part Name: Main Rotor Blade Trim Tab Tools Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/24/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev A 17.10.27 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		9/24/18	0.00	0.00	Start Up Small Fab-2		<i>SMB</i>
110	Small Fab	3 pcs		9/24/18	0.00	3.00	Small Fab-3		<i>SMB</i>
120	QC	3 pcs		9/24/18	0.00	0.00	QC5		<i>18/11/30</i>
130	Packaging	3 pcs		9/24/18	0.00	0.00	Packaging3-1		
140	QC21-FG	3 Ea		9/24/18	0.00	0.00	QC21		

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	12 Ea (4 ea)	90-Start up Operation	<i>5089/28</i>
APP-1450-E	Case	3 Ea (1 ea)	90-Start up Operation	<i>1X 5100960 1X 5100961 1X 5100962</i>
RB41011	Dart Tooling Placard, Aluminum	3 Ea (1 ea)	90-Start up Operation	<i>5021040</i>
RBE703A94-1130-01-01	Immobilizing Clip Assembly	3 Ea (1 ea)	90-Start up Operation	<i>5133621</i>
RBE703A94-1130-01-23	Deflection Clip Assembly	3 Ea (1 ea)	90-Start up Operation	<i>5133643</i>
RBE703A94-1130-01-47	Bottom Foam use in case APP-1450-E	3 pcs (1 ea)	90-Start up Operation	<i>1X 5100947 1X 5100946 1X 5100945</i>
RBE703A94-1130-01-49	Top Foam use in case APP-1450-E	3 pcs (1 ea)	90-Start up Operation	<i>1X 5098543 1X 5098544 1X 5098545</i>

Job Allocations

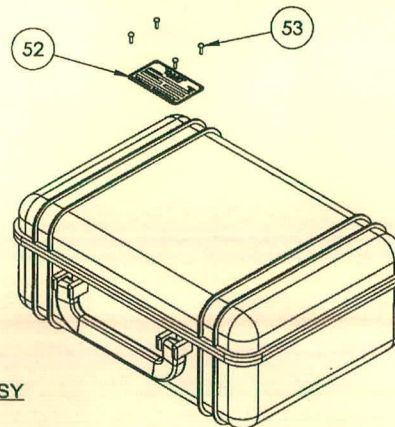
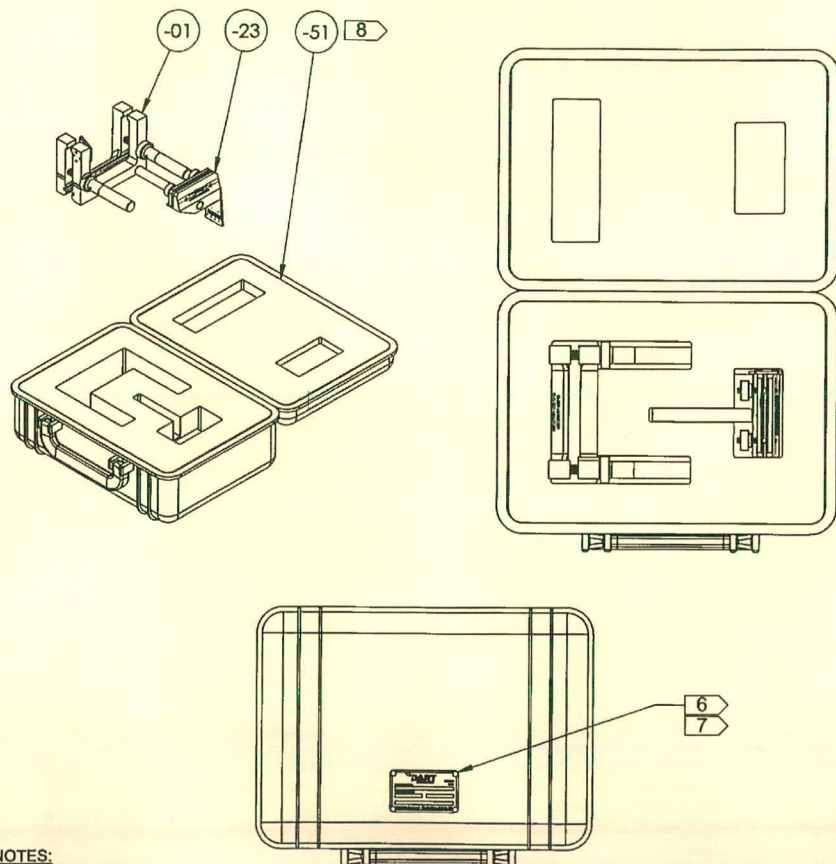
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	12	539	0
	APP-1450-E	3	17	0
	RB41011	3	791	0
	RBE703A94-1130-01-01	3	1	0
	RBE703A94-1130-01-23	3	5	0
	RBE703A94-1130-01-47	3	17	0
	RBE703A94-1130-01-49	3	17	0

Part Specifications

Specifications could not be found.

ITEM #	QTY	PART #	TITLE	PG
-01	1	RBE703A94-1130-01-01	IMMOBILIZING CLIP ASSY	2
-23	1	RBE703A94-1130-01-23	DEFLECTION CLIP ASSY	9
-51	1	RBE703A94-1130-01-51	PACKAGING ASSY	15
52	1	RB41011	DART PLACARD	-
53	4	McMaster#97524A032	RIVET 1/8" x 0.425" LG.	-

REV.	DESCRIPTION	DATE	BY	APPROVED
1	MOVED P/Ns -27, -29 FROM PAGE 3 TO 4. CHD ENGRAVE NOTE P/N -03. CHD HOLE DIA. P/N -25 & ADDED P.F. CHD DOWEL DIM TO METRIC ONLY. CHD P/N -27 ROLL PIN HOLE DIA. TO 4mm ONLY ADDED P.F. CHD RADIUS DIM P/N -21. CHD DOWEL DIM TO 4mm ONLY ADDED DEPTH .354 CHD RADIUS DIM -29.	5/1/2009	RJC	RW
1A	-49 ADDED LID FOAM.	4/13/2011	RJC	RW
2	CHD -03 & -49 NOTE 1 PER R.W. CHD -05 DOWEL PIN HOLE FROM 0.118in. [03mm] PER G.E. -09 CHD C-DRILL FROM 04mm TO 0.170 PER G.E. CHD -11 0.118 HOLE FROM P.F. TO S.F. PER G.E. CHD -21 FROM 03mm x 20mm PER R.W. ADDED -25 DIMENSION 1.25in. [32mm] TO ENSURE -25 WILL S.F. INTO -27 PER G.E. CORRECTED -27 & -29 CHAMFER DIMENSION FROM 1.97in. TO .197 PER G.E. ADDED -51 TO BOM. CHD -41 FROM DOWEL PIN.	9/16/2011	RJC	-
2A	ADDED -09 MISSING 03mm HOLE P.F. -19 DIMENSION. ADDED -27 MISSING R.062 DIMENSION PER G.E.	5/21/2012	RJC	GE
2B	CHD -03 & -09 FINISH FROM CLEAR ANODIZE TO RED ANODIZE, REMOVED POWDER COATING NOTES. CHD -07 WAS #91310A558 STEEL TO #91287A165 S.S. CHD -47 WAS ROLL PIN TO DOWEL PIN	4/17/2013	CFS	RW
3	-03, -09, -27 CHD ENGRAVE NOTE WAS RBE703A94-1130-01 IS RBE703A94-1130-01, -05 CORRECTED VIEWS. CHD DIM WAS 0.315 1.25 IS 0.315 1.25 S.F. CHD DIM WAS 0.129 THRU IS 0.129 125. -07 ADDED DIM S.F. -05. CHD DIM WAS 0.125 FOR -21 IS 0.129/125 THRU. -09 CHD DIM WAS 0.118 P.F. -19 IS 0.118/0076 (x2). -11 CHD DIM WAS 0.118 S.F. -19 (x2) IS 0.1209/1197 (x2). -25 CHD DIM WAS 04mm P.F. -41 IS 0.1575/1572. CHD DIM WAS .625 S.F. -27 IS (.625) S.F. -27 CHD DIM WAS 04mm THRU S.F. -41 IS 0.1607/1592 S.F. -41 CHD DIM WAS 04mm. 354 (x2) IS 0.1575/1572 .35 (x2). ADDED MISSING DIM .236. -31 CHD DIM WAS 0.157 S.F. -41 (x2) IS 0.1607/1592. ADDED MISSING DIM (.394). -47 ADDED DIM (4x) R.37.	6/24/2013	BIM	RW
4	-25 CHD DIM WAS LIMITS 0.1572 TO .1575 IS 0.1564 TO .1570. -27 CHD DIMS WAS 0.1592 TO .1607 IS 0.1575/1590. WAS 0.1572 TO .1575 IS 0.1567/1571. -31 CHD DIM WAS LIMITS 0.1592 TO .1607 IS 0.1578 TO .1685.	4/10/2014	DPD	GE
5	SEE ECR 16-0272	12/30/2016	RJC	SM
6	SEE ECR 17-0164	6/26/2017	RJC	JAG
K	SEE ECN 17 623 : TEMPLATE UPDATE AS PER HAWKESBURY STANDARDS. -07 MATERIAL CHANGE FROM M8 SCREW TO M304R AND TOLERANCE .315/.306 CHANGE TO .307 +0/-003 AND THREAD CLASS ADDED. -05 TOLERANCE .315/.316 CHANGE TO .309 +.003/-0. ASSY -51 ADDED. RIVETS AND EMPLACEMENT OF THE PLACARD ON THE PELICAN CASE ADDED	11/20/2017	VM	WM



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE P/N & S/N WHERE INDICATED ON DART PLACARD (ITEM 52) BEFORE INSTALLATION ON THE PELICAN CASE (ITEM 45)
- 7) CENTER DART PLACARD (ITEM 52) IN AVAILABLE AREA OF THE PELICAN CASE'S LID (ITEM 45)
- 8) HOT GLUE TOP AND BOTTOM FOAM (ITEM -47 & -49) INTO THE PELICAN CASE (ITEM 45) AFTER DART PLACARD'S (ITEM 52) INSTALLATION
- 9) OEM P/N: E-703494-1130-01

RBE703A94-1130-01 MAIN ROTOR BLADE TRIM TAB TOOLS ASSY

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE MAIN ROTOR BLADE TRIM TAB TOOLS ASSY	
DWG NO. RBE703A94-1130-01	REV K
DESIGN BY: VM 9/11/2017	XXX ± .005 FRACTIONS 2/16
DRAWN BY: VM 11/24/2017	XX ± .01 ANGLES 8.5°
CHECKED BY: WM 11/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
MFG. APPR: DP 11/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED BY: WM 11/30/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
DATE: 11/24/2017	SCALE: NTS WEIGHT: N/A SHEET 1 OF 17
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